

Ship July 14

Date: Thursday, 6/29/2006 3:51:49 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET ASSEMBLY
 Job Number : 27790
 Estimate Number : 10770
 P.O. Number : NIA Part Number : D3462041
 This Issue : 6/29/2006 S.O. No. : NIA Drawing Number : D3462 REV.B
 Prsht Rev. : NC Project Number : N/A
 First Issue : NIA Type : LARGE FAB ASSY Drawing Revision : B
 Previous Run : 24915 Material : NIA
 Due Date : 7/12/2006 Qty: 4 Um: Each
 Written By : *See comment below*
 Checked & Approved By : *060629*
 Comment : EST REV. A 05.11.18 NEW ISSUE EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D34623 Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Flange

Pick:

Qty	Part Number	Description	Batch
1	D3462-3	flange	B21852-4

PD

06-07-18

(4)

2.0 D34621F Base Flat Pattern



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Base Flat Pattern

Pick:

Qty	Part Number	Description	Batch
1	D3462-1F	base flat pattern	B21606

PD

06-07-18

(4)

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3462

4.0 QC5/9 WELD INSPECTION



Comment: WELD INSPECTION

5.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

a.m

06/07/21

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 5/6/17/24

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/29/2006 3:51:49 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 27790

Part Number: D3462041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

AL 06/07/21 (4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

AL 06/07/21 (4)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

AL 06/07/21 (4)

AL 06.07.21

Job Completion



AL 06.07.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

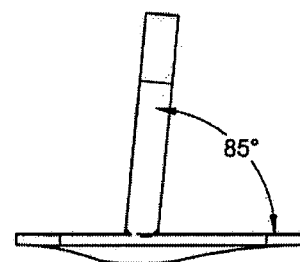
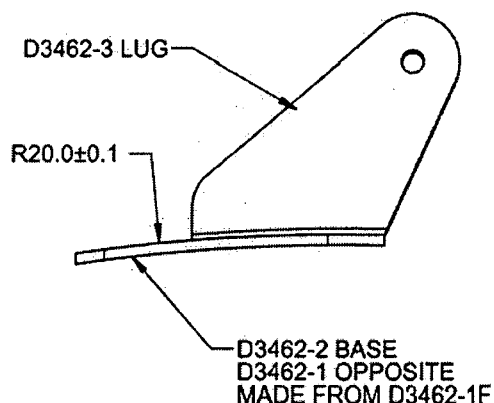
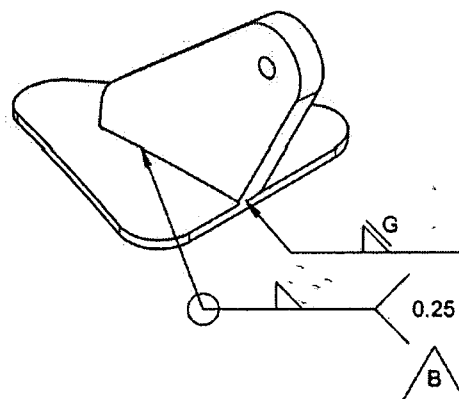
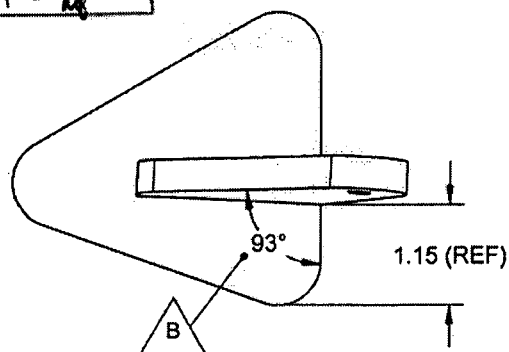
QA: N/C Closed: _____ Date: _____



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3462	REV. B SHEET 1 OF 2
DATE 05.12.05	TITLE BRACKET ASSEMBLY		SCALE 1:2
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIMENSIONS	

RELEASED

05.12.09 [Signature]



D3462-042 BRACKET ASSEMBLY (SHOWN)
D3462-041 OPPOSITE

NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

SHOP COPY

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO.

27790

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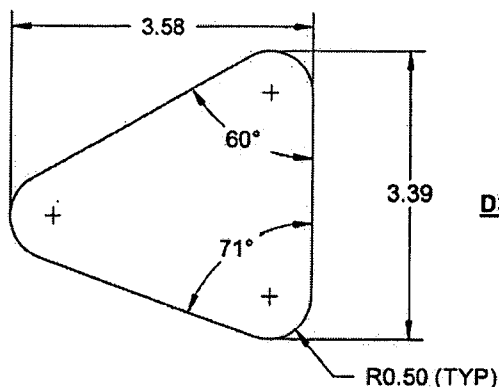
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3462	REV. B SHEET 2 OF 2
DATE 05.12.05		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED

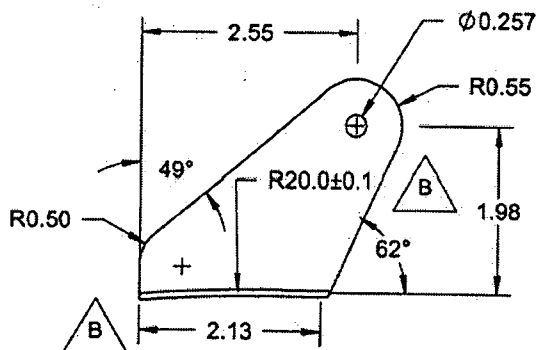
05.12.09 #



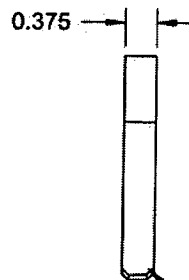
D3462-1F FLAT PATTERN

D3462-1F BASE

- 1) MATERIAL: AISI 304 SS SHEET, 0.125 THICK (REF. DART SPEC. M304S11 GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010



D3462-3 LUG



0.08 x 45°
CHAMFER
(TYP)

D3462-3

- 1) MATERIAL: AISI 304 SS BAR (REF. DART SPEC. M304B)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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